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6. A molded article made by the process of claim 2.

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~~10. A process according to Claim 4, wherein said in-mold coating material comprises at least one acrylic oligomer from a saturated aliphatic~~

polyester urethane intermediate, a saturated (cyclo) aliphatic (meth) acrylate, one or more hydroxy alkyl (meth)acrylates, a polyacrylate ester of an alkylene polyol, one or more vinyl substituted aromatics, and an initiator capable of generating free radicals in said coating composition.

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~~8~~
~~11~~. A process according to Claim ~~10~~, wherein said saturated (cyclo) aliphatic (meth) acrylate is present in said in-mold coating material in an amount of from about 20 to about 100 parts by weight per 100 total parts by weight of said polyester urethane acrylate.

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~~12~~. A process according to Claim ~~10~~, wherein said saturated (cyclo) aliphatic (meth) acrylate is present in said in-mold coating material in an amount of from about 50 to about 80 parts by weight per 100 total parts by weight of said polyester urethane acrylate.

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~~10~~
~~13~~. A process according to Claim ~~10~~, wherein said hydroxy alkyl (meth) acrylates are present in said in-mold coating material in an amount of from about 2 to about 20 parts by weight per 100 parts by weight of said polyester urethane acrylate.

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~~11~~
~~14~~. A process according to Claim ~~10~~, wherein said hydroxy alkyl (meth) acrylates are present in said in-mold coating material in an amount of from about 8 to about 12 parts by weight per 100 parts by weight of said polyester urethane acrylate.

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~~12~~
~~15~~. A process according to Claim ~~10~~, wherein said vinyl substituted aromatics are present in said in-mold coating material in an amount of from about 10 to about 70 parts by weight per 100 parts by weight of said polyester urethane acrylate.

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16. A process according to Claim 10, wherein said polyacrylate ester of an alkylene polyol is present in said in-mold coating material in an amount of from about 10 to about 40 parts by weight for per 100 parts by weight of said polyester urethane acrylate.

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17. A process according to Claim 10, wherein said polyacrylate ester of an alkylene polyol is present in said in-mold coating material in an amount of from about 20 to about 30 parts by weight for per 100 parts by weight of said polyester urethane acrylate.

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18. A process according to Claim 10, wherein said in-mold coating material composition comprises graphite, titanium dioxide, carbon black and talc.

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19. A process according to Claim 10, wherein said saturated (cyclo) aliphatic (meth) acrylate is isobornyl acrylate.

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20. A process according to Claim 10, wherein said hydroxy alkyl (meth) acrylate is hydroxypropyl methacrylate.

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21. A process according to Claim 10, wherein said polyacrylate ester of an alkylene polyol is hexane diol acrylate.

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22. A process according to Claim 10, wherein said initiator is selected from the group consisting of tertiary butyl perbenzoate, tertiary butyl peroctoate and mixtures thereof.

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23. A process according to Claim 22, wherein said initiator is tertiary butyl perbenzoate.

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24. A process according to Claim 10, wherein said initiator comprises a peroxide compound.

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25. A process according to Claim 10, wherein said initiator comprises an azo-initiator.

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26. A process according to Claim 24, wherein said peroxide compound is selected from the group consisting of diacetyl peroxide in dimethyl phthalate, dibenzoyl peroxide, di (p-chlorobenzoyl) peroxide in dibutyl phthalate, di (2,4-dichlorobenzoyl) peroxide in dibutyl phthalate, dilauroyl peroxide, methyl ethyl ketone peroxide, cyclohexanone peroxide in dibutyl phthalate, 3,5-dihydroxy-3,4-dimethyl-1,2-dioxacyclopentane, t-butylperoxy (2-ethyl hexanoate), caprylyl peroxide, 2,5-dimethyl-2,5-di (benzoyl peroxy) hexane, 1-hydroxy cyclohexyl hydroperoxide-1, t-butyl peroxy (2-ethyl butyrate), 2,5-dimethyl-2,5-bis (t-butyl peroxy) hexane, cumylhydroperoxide, diacetyl peroxide, t-butyl hydroperoxide, ditertiary butyl peroxide, 3,5-dihydroxy-3,5-dimethyl-1,2-oxacyclopentane, 1,1-bis (t-butylperoxy)-3,3,5-trimethyl cyclohexane, and mixtures thereof.

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27. A process according to Claim 3, wherein said coated thermoplastic workpiece is suitable for use as is in an end use application.

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28. A process according to Claim 10, wherein said initiator is present in an amount of from about .25% to about 5% by weight based upon the total weight of the components comprising said in-mold coating material.

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29. A process according to Claim 10, wherein said initiator is present in an amount of from about 1% to about 2% by weight based upon the total weight of the components comprising said in-mold coating material.

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30. A process according to Claim 3, wherein said thermoplastic substrate is a polycarbonate alloy.

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31. A process according to Claim 3, wherein said thermoplastic substrate is a polyester.

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32. A molded article as in Claim 3 which comprises a coated polypropylene workpiece.

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33. A molded polycarbonate alloy workpiece comprising a thermoset coating bonded thereto, said coating further comprising a component capable of generating free radicals.

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34. A molded workpiece according to Claim 33, wherein said component capable of generating free radicals is a peroxide initiator.

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35. A molded polyester workpiece comprising a thermoset coating bonded thereto, said coating further comprising at least one acrylic oligomer from a saturated aliphatic polyester urethane intermediate, a saturated (cyclo) aliphatic (meth) acrylate, one or more hydroxy alkyl (meth)acrylates, a polyacrylate ester of an alkylene polyol, one or more vinyl substituted aromatics, and an initiator capable of generating free radicals in said coating composition.

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